

Date: Friday, 20/10/2006 2:32:00 PM  
 User: Linda Lacelle

## Process Sheet

Split 06.10.27

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 29087-1  
 Estimate Number : 12557  
 P.O. Number : N/A  
 This Issue : 20/10/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : 20/10/2006 Type : MACHINED PARTS  
 Previous Run : N/A  
 Written By : \_\_\_\_\_  
 Checked & Approved By : \_\_\_\_\_  
 Comment : Est Rev:A 06.10.20 New issue ec

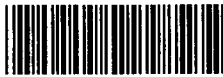
Drawing Name : REPLACEMENT SHIM KIT

Part Number : D412698021  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material : N/A  
 Due Date : 11/11/2006

Qty: 4 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-021 CHG001

KS 06.10.23.

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

MAKE D3238-1 (3 PER KIT)

PER DRWG D3238 REV.A

06 10 20

3.0

M2024T3S080

2024-T3 .080 sheet



Comment: Qty.: 0.0360 sf(s)/Unit Total: 0.1800 sf(s)

2024-T3 .080 sheet

M18481 W 06 10 26

4.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

MAKE D3238-3 (1 PER KIT)

PER DRWG D3238 REV.A

06 10 26

5.0

M2024T3S080

2024-T3 .080 sheet



Comment: Qty.: 0.0120 sf(s)/Unit Total: 0.0600 sf(s)

2024-T3 .080 sheet

M18481 W 06 10 25

Date: Friday, 20/10/2006 2:32:00 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT SHIM KIT

Job Number: 29087

Part Number: D412698021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(10) ✓



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE D3238-5 (2 PER KIT)

PER DRWG D3238 REV.A

MM OB 10 25

(10)

7.0

M2024T3S080

2024-T3 .080 sheet



Comment: Qty.: 0.0240 sf(s)/Unit Total: 0.1200 sf(s)

2024-T3 .080 sheet M18481

MM OB 10 26

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(12) ✓



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE D3238-11 (6 PER KIT)

PER DRWG D3238 REV.A

MM OB 10 27

(12)

9.0

M5052H32S020

5052-H32 .020 Sheet



Comment: Qty.: 0.0720 sf(s)/Unit Total: 0.3600 sf(s)

5052-H32 .020 Sheet M3019

MM OB 10 27

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(2)



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE D3238-13 (2 PER KIT)

PER DRWG D 3238 REV.A

MM OB 10 27

(2)

11.0

M5052H32S020

5052-H32 .020 Sheet



Comment: Qty.: 0.0240 sf(s)/Unit Total: 0.1200 sf(s)

5052-H32 .020 Sheet M3019

MM OB 10 27

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(4)



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE D3238-15 (4 PER KIT)

PER DRWG D3238 REV.A

MM OB 10 27

(4)

Date: Friday, 20/10/2006 2:32:00 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT SHIM KIT

Job Number: 29087

Part Number: D412698021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

M5052H32S020

5052-H32 .020 Sheet



Comment: Qty.: 0.0480 sf(s)/Unit Total: 0.2400 sf(s)

5052-H32 .020 Sheet

M 3019

M 8 10 27

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Doc 1201

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-021

3 X D3238-1 B 29087

1 X D3238-3 B 29087

2 X D3238-5 B 29087

6 X D3238-11 B 29087

2 X D3238-13 B 29087

4 X D3238-15 B 29087

Location:

PPP Rev: DART

11/12/22 (1)  
11-30  
One kit taken from #12

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Doc 12122 (1)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doc 12122 (1)

Job Completion



Doc 12122

06/12/21

14b

and other machine

m.k

14c

QC3

Job 1202



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3238	REV. A SHEET 1 OF 1
DATE 03.11.25	TITLE PLATE	SCALE 1:1	
A	03.11.25	NEW ISSUE	

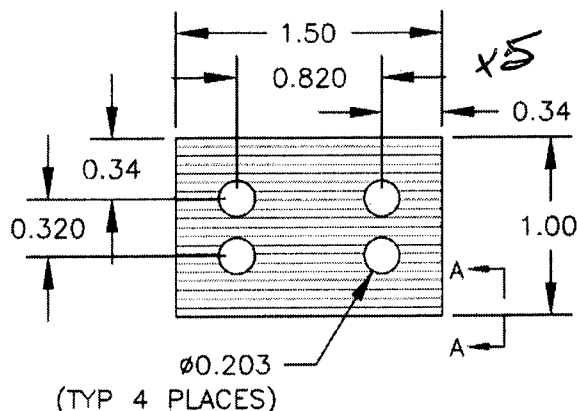
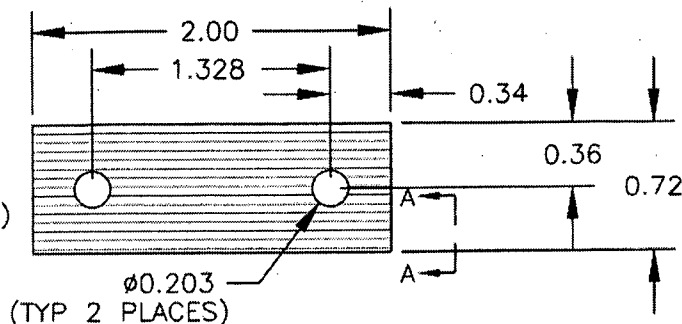
RELEASED

03.12.19

**D3238-1 PLATE (SHOWN)**

**D3238-11 PLATE (SIMILAR)**

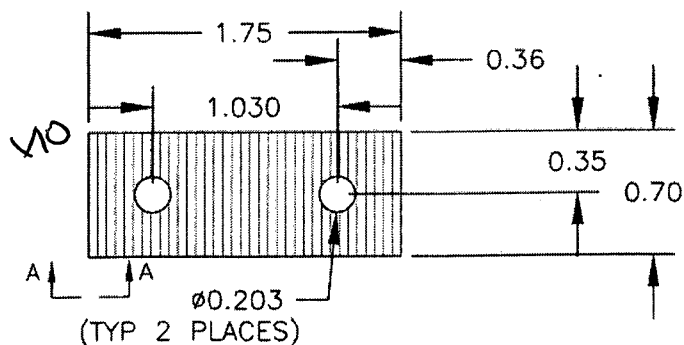
(SAME, EXCEPT 0.020" THICK, NO SERATIONS)



**D3238-3 PLATE (SHOWN)**

**D3238-13 PLATE (SIMILAR)**

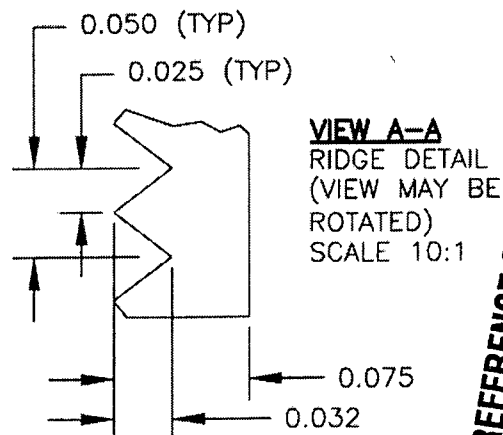
(SAME, EXCEPT 0.020" THICK, NO SERATIONS)



**D3238-5 PLATE (SHOWN)**

**D3238-15 PLATE (SIMILAR)**

(SAME, EXCEPT 0.020" THICK, NO SERATIONS)



REFERENCE ONLY

**D3238-1/-11/-3/-13/-5/-15 PLATE**

- 1) MATERIAL, -1/-3/-5: 2024-T3 SHEET (QQ-A-250/4) (REF DART SPEC M2024T3S)  
-11/-13/-15: 5052-H32 SHEET (QQ-A-250/8) (REF DART SPEC. M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 004 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Friday, 10/20/2006 11:10:10 AM

Kim Johnston

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 29087  
**Estimate Number** : 12557  
**P.O. Number** :  
**This Issue** : 10/20/2006 **S.O. No.** :  
**Prsht Rev.** : NC  
**First Issue** : / / **Type** : MACHINED PARTS  
**Previous Run** :  
**Written By** :  
**Checked & Approved By** : *06 10 20*  
**Comment** : Est Rev:A 06.10.20 New issue ec

**Drawing Name** : REPLACEMENT SHIM KIT  
**Part Number** : D412698021  
**Drawing Number** : N/A  
**Project Number** : N/A  
**Drawing Revision** : N/A  
**Material** :  
**Due Date** : 11/11/2006 **Qty:** 5 **Um:** Each

(P10) →

## Additional Product

Job Number:

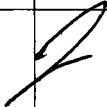



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-698-021 CHG001		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	D32381	Plate
Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s) Plate Batch: _____		
4.0	D32383	Plate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Plate Batch: _____		
5.0	D32385	Plate
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Plate Batch: _____		


*2024 135080*

*012 sf*


Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/27	14.0	Split w/o for qty of 1 kit.		06/10/27	1 kit		 06/10/27

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/20/2006 11:10:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT SHIM KIT

Job Number: 29087

Part Number: D412698021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D323811

Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Plate

Batch: \_\_\_\_\_

*50521132020*  
*-012*

7.0

D323813

Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Plate

Batch: \_\_\_\_\_

8.0

D323815

Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Plate

Batch: \_\_\_\_\_

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-021

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 29087
<b>Description:</b> Plate	<b>Part Number:</b> D3238-5
<b>Inspection Dwg:</b> D3238 Rev: A	Page 1 of 1







